

Work Order ID 91273

October-05-12 9:15:41 AM

91273

Page 1

Item ID: 647.4712 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Doubler
 Start Date: 10/05/12 Start Qty: 15.00 ***15*** Cust Item ID:
 Required Date: 10/31/12 Req'd Qty: 15.00 ***15*** Customer:
 Reference:

Approvals: Process Plan: ML5 Date: 12-10-05 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
647.4700	N/C								

110 0.00
110
 Waterjet Memo 0.00 15 0 Jm 12-10-14
 FLOW CNC Waterjet 1-Cut as per Dwg
 Dwg Rev: A/C
 Prog Rev: A/C
 2-Deburr if necessary

120 QC2- Inspect parts off machine FAI/FAIB 0.00
120
 QC Memo 0.00 15 0 Jm 12-10-14
 Quality Control

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Page 2

Item ID: 647.4712

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Doubler

Stop ***NS2***

Start Date: 10/05/12 Start Qty: 15.00

15

Cust Item ID:

Required Date: 10/31/12 Req'd Qty: 15.00

15

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

140

Outsource process-Anodize per QSI017 4.1.10.1

0.00

140

Outsource4

Memo

0.00

Outsource process - Anodize

HARD ANODIZE, COLOR BLACK AS PER DWG.(SEE NOTE 2)

150

Receive & Inspect for Damage & Mat'l Certs

0.00

150

Packaging

Memo

0.00

Packaging

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Page 3

Accept

Setup Start *NS1*

Stop *NS2*

Start Date: 10/05/12 **Start Qty:** 15.00 ***15***

Cust Item ID:

Required Date: 10/31/12 **Req'd Qty:** 15.00 ***15***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Operation Description

Set Up/ Run Hours

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

170

0.00

170

SprayPaint

Memo

0.00

Spray Painting

PRIME IAW MIL-P-23377J TYPE1 CLASS N AS PER DWG. (SEE NOTE 2)

CARDINAL 4860-50 PRIMER BATCH: 123693

180

QC14- Inspect Spray Paint

0.00

180

QC

Memo

0.00

Quality Control

Work Order ID 91273

91273

Page 4

October-05-12 9:15:41 AM

Item ID: 647.4712 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Doubler
 Start Date: 10/05/12 Start Qty: 15.00 *15* Cust Item ID:
 Required Date: 10/31/12 Req'd Qty: 15.00 *15* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location	0.00							
190									
Packaging	Memo	0.00							
Packaging	***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***								
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

DAS 12/11/20
05
8-83

12/11/21 (15)

12/11/22

ME
12-11-20

Picklist Print

October-05-12 9:15:40 AM

Page 1

Work Order ID: 91273

Parent Item: 647.4712

Parent Item Name: Doubler

Start Date: 10/05/12

Required Date: 10/31/12

Start Qty: 15.00

Required Qty: 15.00

Comments: IPP REV:A 12.09.19 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M2024T3S.050

2024-T3 .050 sheet

Purchased

No

110

sf

203.8484

0.825

~~13.026316~~
13.5

Jm 12-10-14

Location

Loc Qty

Loc Code

MAT022

203.8484204

117684

17.8

121216

71.4484204

121889

114.6

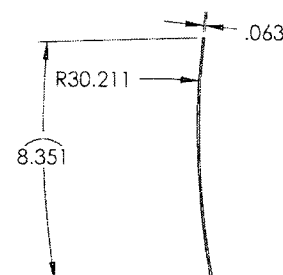
121216

NOTES: UNLESS OTHERWISE SPECIFIED

- SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 91273 ML

647.4711

.063

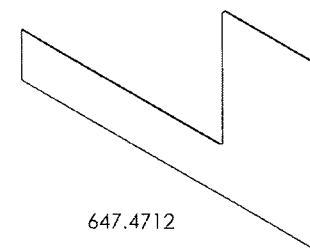


	1	647.4719	CLIP FWD	△	△
	1	647.4718	CLIP AFT RH	△	△
	1	647.4717	CLIP AFT LH	△	△
	1	647.4716	SPACER	△	△
	1	647.4715	CLIP RH	△	△
	1	647.4714	CLIP LH	△	△
	1	647.4713	BRACKET	△	△
	1	647.4712	DOUBLER	△	△
	1	647.4711	DOUBLER	△	△
		PART #	DESCRIPTION	MAT'L	SPEC.
QTY			PARTS LIST		
NEXT ASSY (S) 647.2600			APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5334		
CHECKED DATE: 10/20/00 DRAWN: J. BARNER DRAWING APPROVAL: (Signature) ELEMOR: (Signature) CONTRACT NO.			SHEETMETAL 647.4700		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 1/16" DECIMALS ± .005 3/16" DECIMALS ± .003 1/2" DECIMALS ± .003			SOL CODE: 0000 B DPMG: 647.4700 SCALE: NONE LUBED: 1 OR 2		

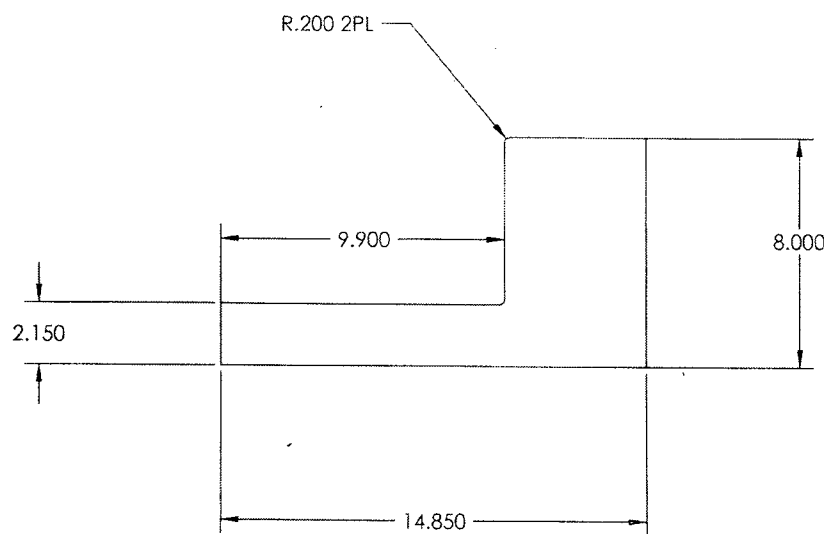
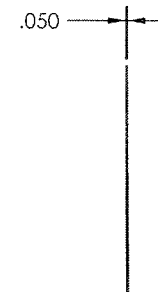
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REV		DESCRIPTION	DATE	APPROVED

91273



647.4712

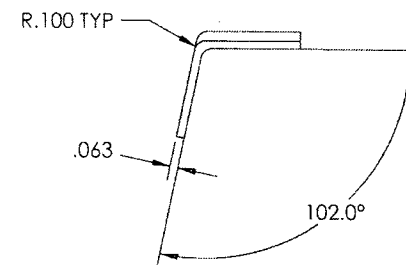
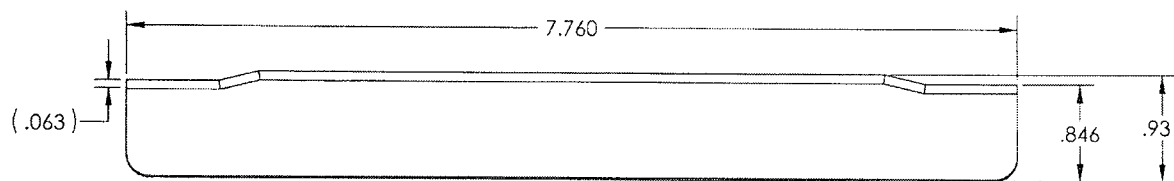
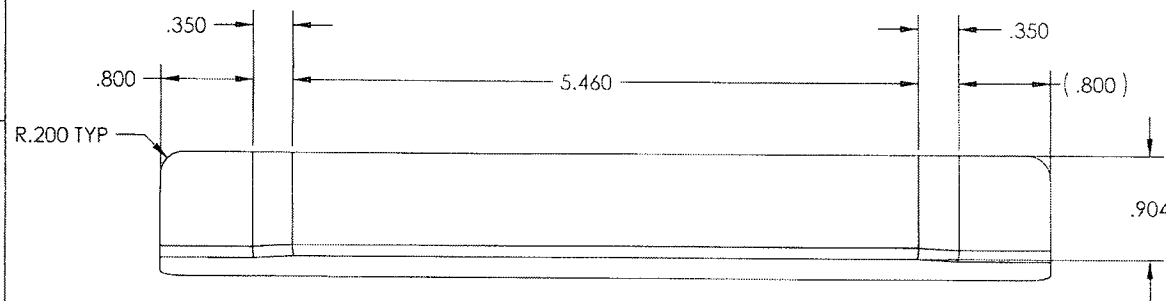
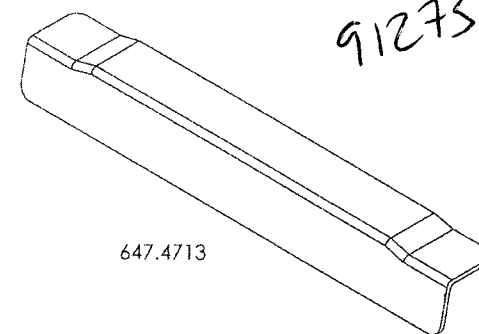


ORIGINAL DATE AND DWT		DESIGNED BY A. OLARI		CHECKED BY D. BAYLER	
DRAWING APPROVAL DATE		CONTRACT NO.		SHEETMETAL	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES DIMENSIONS ARE SERVICES DIMENSIONS 201 ANGLES 2 1/2		SHEET	CAGE CODE B 07M16	DWG NO. 647.4700	REV. N/C
SCALE: NONE		SHEET		2 OF 7	

APICAL INDUSTRIES
2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA. 92036-3312 (760)724-5300

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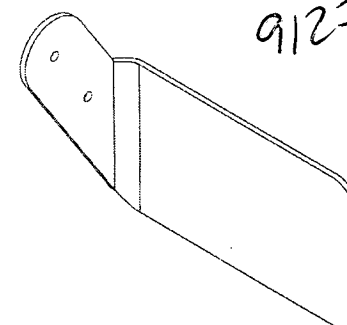
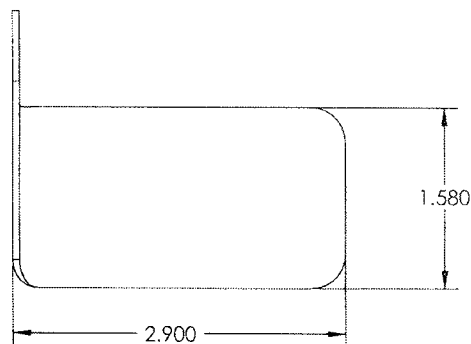
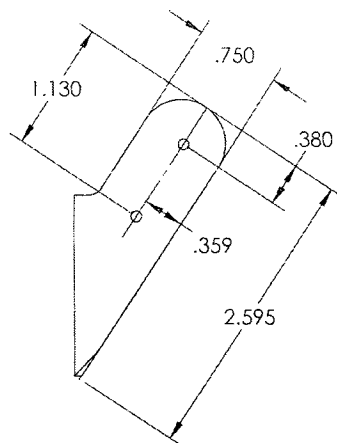
REV	DESCRIPTION	DATE	APPROVED



OFFICIAL DATE 10/13/09 DRAWN BY J. DUNN CHECKED BY J. DUNN DRAWING APPROVAL J. DUNN CONTRACT NO.	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 1760/724-5300 SHEETMETAL
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES DECIMALS ARE 3 PLACE DECIMALS 4 D. 3 PLACE DECIMALS 2 D. ANGLES ± .1°	REV. CASE CODE B 07M25 SCALE NONE
DWG. NO. 647.4700 SHEET 3 OF 7	REV. HVC

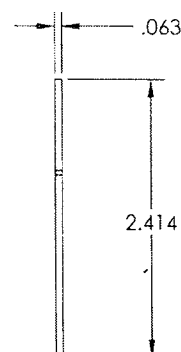
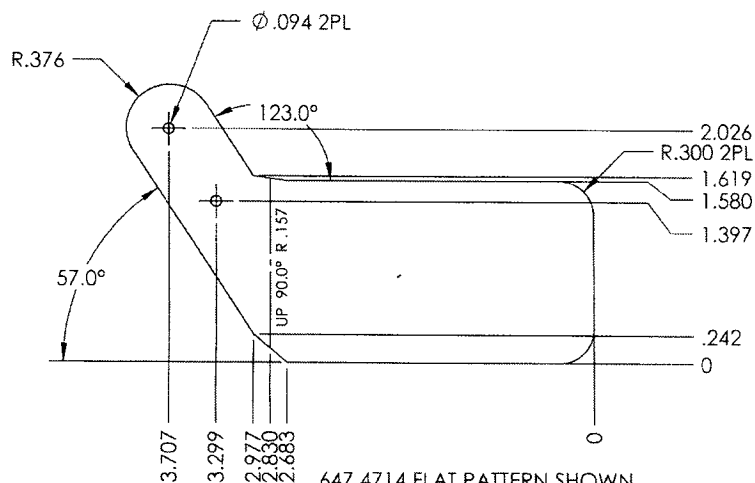
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REV	DESCRIPTION	DATE	APPROVED



91273

647.4714 SHOWN
647.4715 OPPOSITE



647.4714 FLAT PATTERN SHOWN
647.4715 BEND DOWN

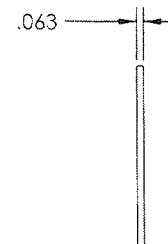
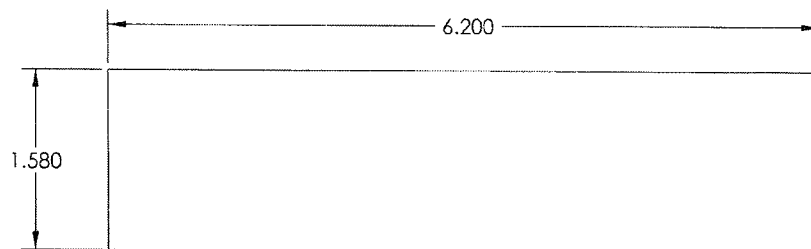
ORIGINAL DATE 06/04/19 DRAWN BY A. GUAN CHECKED BY D. HARPER DRAWING APPROVAL DATE 06/04/19 DESIGNED BY 06/04/19		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724 5300	
SHEET B 07/02/26		SHEETMETAL DWG NO 647.4700	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES DECIMALS ARE 3 PLACE DECIMALS 1000 ANGLES 1/2°		SCALE NONE SHEET 4 OF 7	

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REVISIONS			
REV	DESCRIPTION	DATE	APPROVED

91273

647.4716

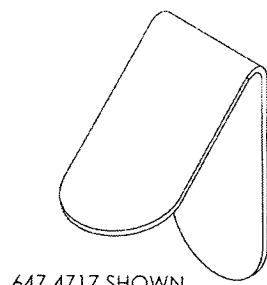


ORIGINAL DATE 10/13/00		APICAL INDUSTRIES	
DESIGNED BY: J. HICKS		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
A. QUART: D. BARBER		SHEETMETAL	
DRAWING APPROVAL BY: J. HICKS		SHEET CODE B 07626	
CONSTRUCTION		DWG NO 647.4700	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE FRACTIONS DECIMALS ANGLES ± .5°		SCALE: NONE	
		SHEET 5 OF 7	

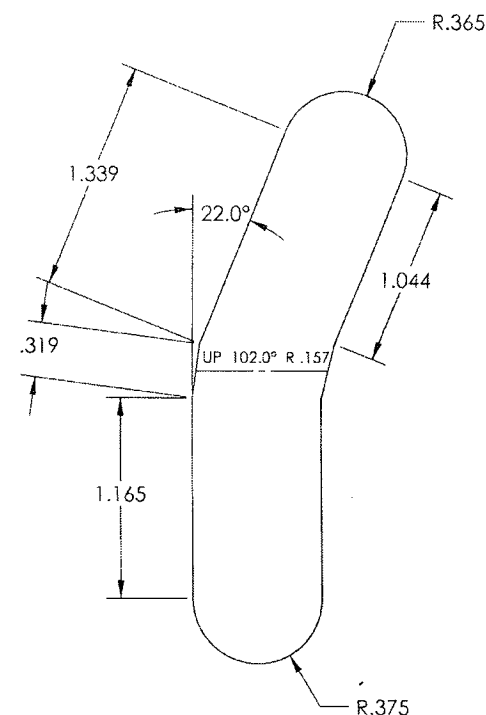
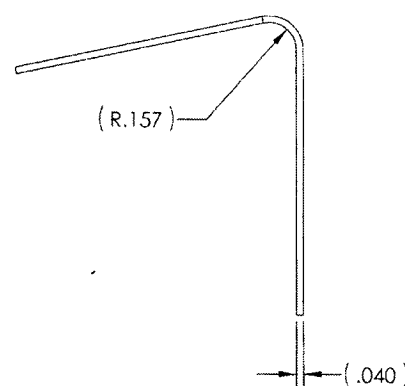
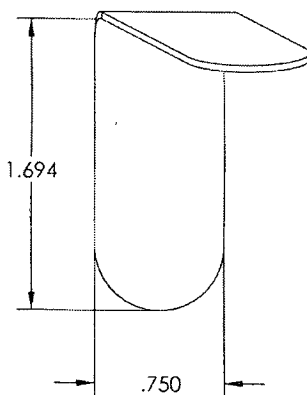
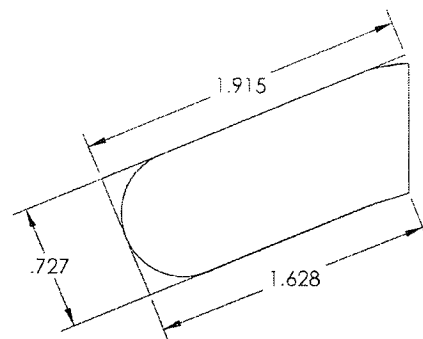
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REVISIONS			
REV	DESCRIPTION	DATE	APPROVED

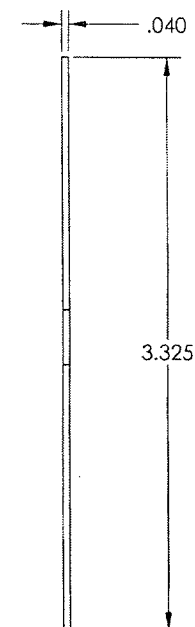
91273



647.4717 SHOWN



647.4717 FLAT PATTERN SHOWN
647.4718 BEND DOWN

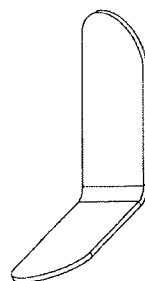
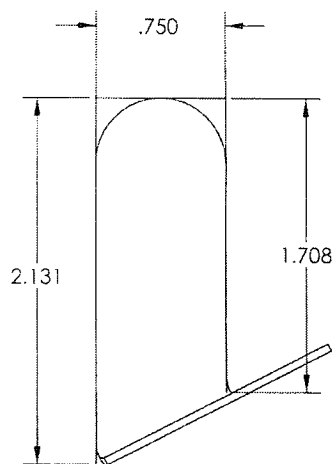


ORIGINAL DATE: 01/13/00		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS CR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWN BY: A. COHAN	CHECKED BY: D. BARTER		
DRAWING APPROVAL: [Signature]		SHEETMETAL	
CONTRACT NO.:		SRI: 07M26	DWG. NO. 647.4700
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: FRACTIONS DECIMALS ±.01 ANGLES ±.5°		SCALE: NONE	SHEET 6 OF 7

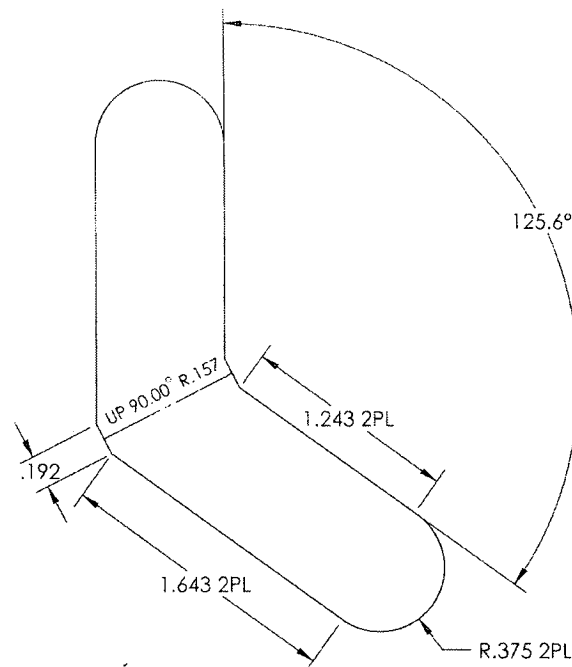
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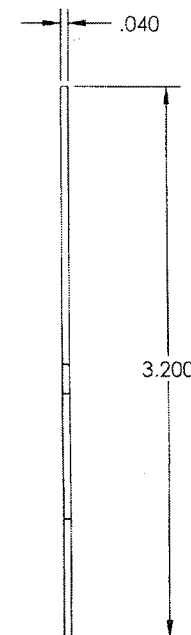
91273



647.4719



647.4719 FLAT PATTERN



<small> ORIGINAL DATE (MM-DD-YY) 10-11-09 DRAWN BY A. QUINN CHECKED BY J. BLANKET GRADED BY APPROVAL P. BLANKET 10/11/09 CONTRACT NO. </small>	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR OCEANSIDE, CA 92056-3512 (760)724-5300
<small> UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5° </small>	SHEETMETAL SEE LARGE DETAILS 8 07M26 SCALE: NONE
647.4700 N/C	REV N/C SHEET 7 OF 7



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 62027

Date: 05-Nov-12

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description		
1 lot	Part: ASST 10 PCS 646.9813 10 PCS 646.9811 10 PCS 646.9812 10 PCS 646.9812 2 PCS 646.9811 15 PCS 646.4711 15 PCS 647.4716 15 PCS 647.4712 15 PCS 647.4717 15 PCS 647.4714 15 PCS 647.4715 15 PCS 647.4718 HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 Job: 20120674	Rev:	PO: PO18153 Line:
1 lot	Part: ASST 7 PCS 647.1810 14 PCS 647.1811 91 PCS 647.1812 2 PCS 647.1612 HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 Job: 20120673	Rev:	PO: PO18304 Line:
		Certificate of Conformance	



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 62027

Date: 05-Nov-12

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To

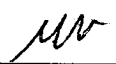
DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via
Quantity	Description	
	A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order.	
	ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY	
	DATE : <u>5/11/12</u>	
	CERTIFIED SIGNATURE : <u></u>	
	RECEIVER SIGNATURE : _____	